

Date: Friday, 9/1/2006 12:06:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 02.250 SUPPORT
Job Number	: 28388		
Estimate Number	: 11057		
P.O. Number	: N/A	Part Number	: D28911
This Issue	: 9/1/2006 S.O. No. N/A	Drawing Number	: D2891 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A1
Previous Run	: 28077	Material	: N/A
Written By	:	Due Date	: 9/30/2006 Qty: 10 Um: Each
Checked & Approved By	: CK 06/09/01		
Comment	: Est. C 02.11.26 Added P/O KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>1954</u> <u>C 606/09/05</u> (10) Description: D6104-003 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required. Blank size makes (2) D2891-1 <u>3.25 + 3.80</u>
2.0	D6104003	17-4 SS Roundbar 3.25"OD
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Support 2.25 dia
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <u>LBO6/09/13</u>
4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
		<u>Issue P.O 2068</u> <u>C 606/09/18 (10)</u> Turn blank for Haas as per Folio FA046 <u>turn per DSK076</u>
5.0	QC1	INSPECT ALL DIM TO DIM SHEET
		<u>R6</u> <u>Receive + inspect for transit damage</u> <u>10/10/06 (10)</u>
		Comment: INSPECT ALL DIM TO DIM SHEET
		<u>5b Inspect levels 5</u> <u>Er 06/10/4</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:06:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 02.250 SUPPORT
Job Number: 28388		Part Number: D28911
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS Machine as per Folio FA046 Tumble & Deburr		<i>EP 06/10/16 X</i>
7.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>EP oct/06 X</i>
8.0	QC8 	SECOND CHECK
Comment: SECOND CHECK		<i>JL 06/10/16</i>
9.0	POWDER COATING 	POWDER COATING <i>M101575</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		<i>YL 06/10/30 X</i>
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>YL 06/10/30 X '0 2067</i>
11.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST166</i>		<i>P 06/10/31 20 mey</i>
12.0	DC 	DOCUMENT CONTROL <i>(16)</i>
Comment: DOCUMENT CONTROL Inspection Level 21		<i>06/10/31</i>
Job Completion		 <i>(Loc) 06/10/31</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28388
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.274	2.279		2.279	2.279	2.279	2.279		
B	3.702	3.722		3.711	3.710	3.707	3.711		
C	2.564	2.584		2.572	2.574	2.578	2.572		
D	0.718	0.738		0.719	0.713	0.718	0.716		
E	0.090	0.110		0.093	0.104	0.092	0.095		
F	2.464	2.484		2.474	2.473	2.474	2.470		
G	2.029	2.049		2.038	2.043	2.038	2.037		
H	2.964	2.984		2.973	2.974	2.972	2.972		
I	0.913	0.933		0.928	0.930	0.920	0.923		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.090	0.110		0.098	0.095	0.094	0.095		
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.189	0.189	0.189	0.189		
AB	0.240	0.260		0.250	0.247	0.247	0.246		
AC	0.115	0.150		0.122	0.122	0.124	0.123		
AD	0.040	0.060		0.044	0.049	0.045	0.048		
AE	0.010	0.020		0.015	0.015	0.015	0.015		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.290	0.310		0.308	0.303	0.306	0.297		
AH	0.115	0.150		0.138	0.136	0.137	0.136		
AI	0.454	0.474		0.460	0.460	0.460	0.460		
AJ	2.779	2.789		2.780	2.780	2.780	2.781		
AK	0.240	0.260		0.250	0.250	0.250	0.250		
AL	1.002	1.042		1.042	1.047	1.042	1.041		
AM	0.053	0.073		0.063	0.063	0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
AO	1.663	1.683		1.678	1.676	1.677	1.671		
AP	0.053	0.073		0.063	0.063	0.063	0.063		
AQ	0.022	0.042		0.032	0.032	0.032	0.032		
AR									
AS									
Accept/Reject									

Measured by:	<i>EP</i>	Audited by:	<i>JL</i>
Date:	<i>06/10/16</i>	Date:	<i>06/10/16</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>TT</i>	<i>#</i>

DART AEROSPACE LTD	Work Order:	28388
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	84	By	Date
Lathe Section									
A	2.274	2.279		2.279	2.279	2.279	2.279		
B	3.702	3.722		3.713	3.714	3.712	3.711		
C	2.564	2.584		2.543	2.544	2.574	2.571		
D	0.718	0.738		0.729	0.729	0.728	0.726		
E	0.090	0.110		0.091	0.093	0.100	0.100		
F	2.464	2.484		2.471	2.474	2.471	2.473		
G	2.029	2.049		2.031	2.036	2.031	2.033		
H	2.964	2.984		2.973	2.974	2.974	2.973		
I	0.913	0.933		0.917	0.928	0.925	0.922		
J	0.022	0.042		0.032	0.032	0.037	0.032		
K	0.090	0.110		0.095	0.095	0.100	0.095		
L									
HAAS Section									
AA	0.188	0.193	DT8706	0.190	0.190	0.190	0.190		
AB	0.240	0.260		0.251	0.246	0.246	0.248		
AC	0.115	0.150		0.127	0.125	0.121	0.123		
AD	0.040	0.060		0.051	0.051	0.050	0.049		
AE	0.010	0.020		0.015	0.015	0.015	0.015		
AF	0.240	0.260		0.250	0.250	0.250	0.250		
AG	0.290	0.310		0.299	0.301	0.301	0.303		
AH	0.115	0.150		0.136	0.137	0.135	0.137		
AI	0.454	0.474		0.461	0.460	0.460	0.459		
AJ	2.779	2.789		2.780	2.782	2.781	2.780		
AK	0.240	0.260		0.252	0.250	0.252	0.250		
AL	1.002	1.042		1.040	1.042	1.040	1.040		
AM	0.053	0.073		0.063	0.063	0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
AO	1.663	1.683		1.677	1.680	1.674	1.672		
AP	0.053	0.073		0.063	0.063	0.063	0.063		
AQ	0.022	0.042		0.032	0.032	0.032	0.032		
AR									
AS									

Accept/Reject

Measured by:	EP	Audited by:	JL
Date:	06/10/15	Date:	06/10/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	*

DART AEROSPACE LTD

Work Order: 28388

Description: Ø2.250 Support

Part Number: D2891-1

Inspection Dwg: D2891 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions			
Dim	Min	Max	Go/No Go Gauge	✓ 19	✓ 16	✓ 10	✓ 14
Lathe Section							
A	2.274	2.279		2.275	2.275		
B	3.702	3.722		3.711	3.712		
C	2.564	2.584		2.574	2.576		
D	0.718	0.738		0.722	0.722		
E	0.090	0.110		0.094	0.099		
F	2.464	2.484		2.483	2.484		
G	2.029	2.049		2.031	2.036		
H	2.964	2.984		2.974	2.976		
I	0.913	0.933		0.928	0.928		
J	0.022	0.042		0.032	0.032		
K	0.090	0.110		0.095	0.097		
L							
HAAS Section							
AA	0.188	0.193	DT8706	0.190	0.191		
AB	0.240	0.260		0.247	0.253		
AC	0.115	0.150		0.121	0.121		
AD	0.040	0.060		0.047	0.055		
AE	0.010	0.020		0.015	0.015		
AF	0.240	0.260		0.250	0.250		
AG	0.290	0.310		0.299	0.306		
AH	0.115	0.150		0.138	0.137		
AI	0.454	0.474		0.458	0.455		
AJ	2.779	2.789		2.780	2.780		
AK	0.240	0.260		0.250	0.250		
AL	1.002	1.042		1.040	1.041		
AM	0.053	0.073		0.063	0.063		
AN	0.257	0.262	DT8683	0.260	0.260		
AO	1.663	1.683		1.677	1.675		
AP	0.053	0.073		0.063	0.063		
AQ	0.022	0.042		0.032	0.032		
AR							
AS							
Accept/Reject							

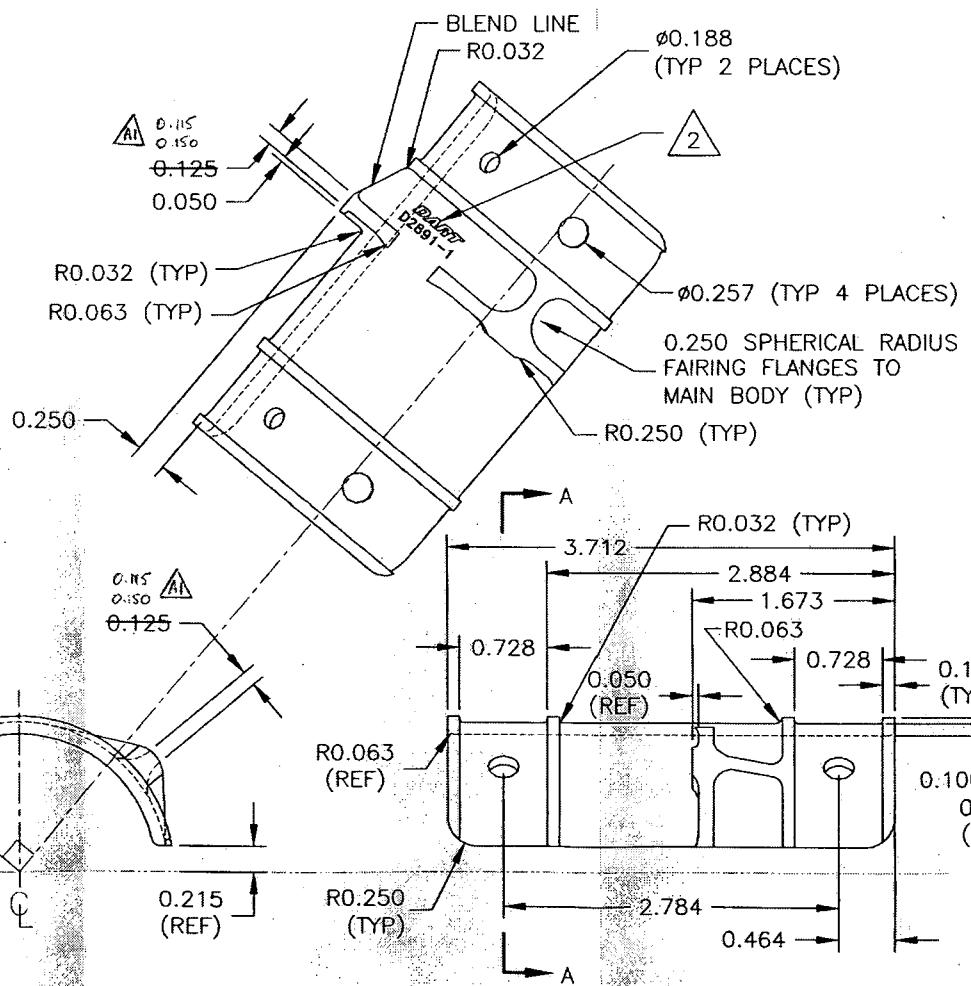
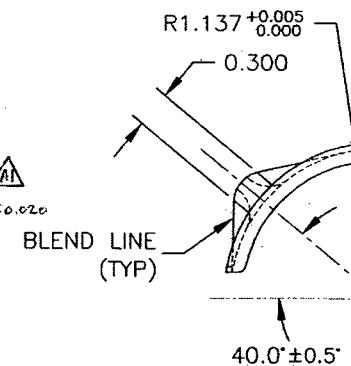
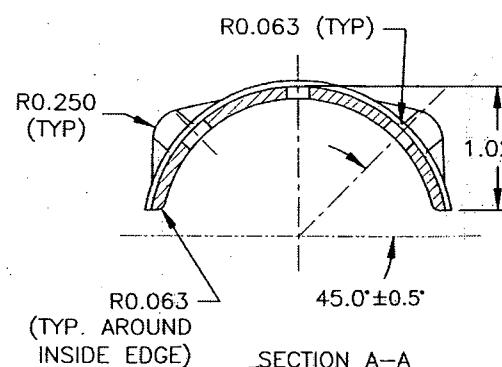
Measured by:	EP
Date:	06/10/16

Audited by:	JL
Date:	06/10/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	#

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PÉR DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF.
 $X_{XXX} = \pm 0.010$) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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WORK ORDER
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SUBJECT TO AMENDMENT

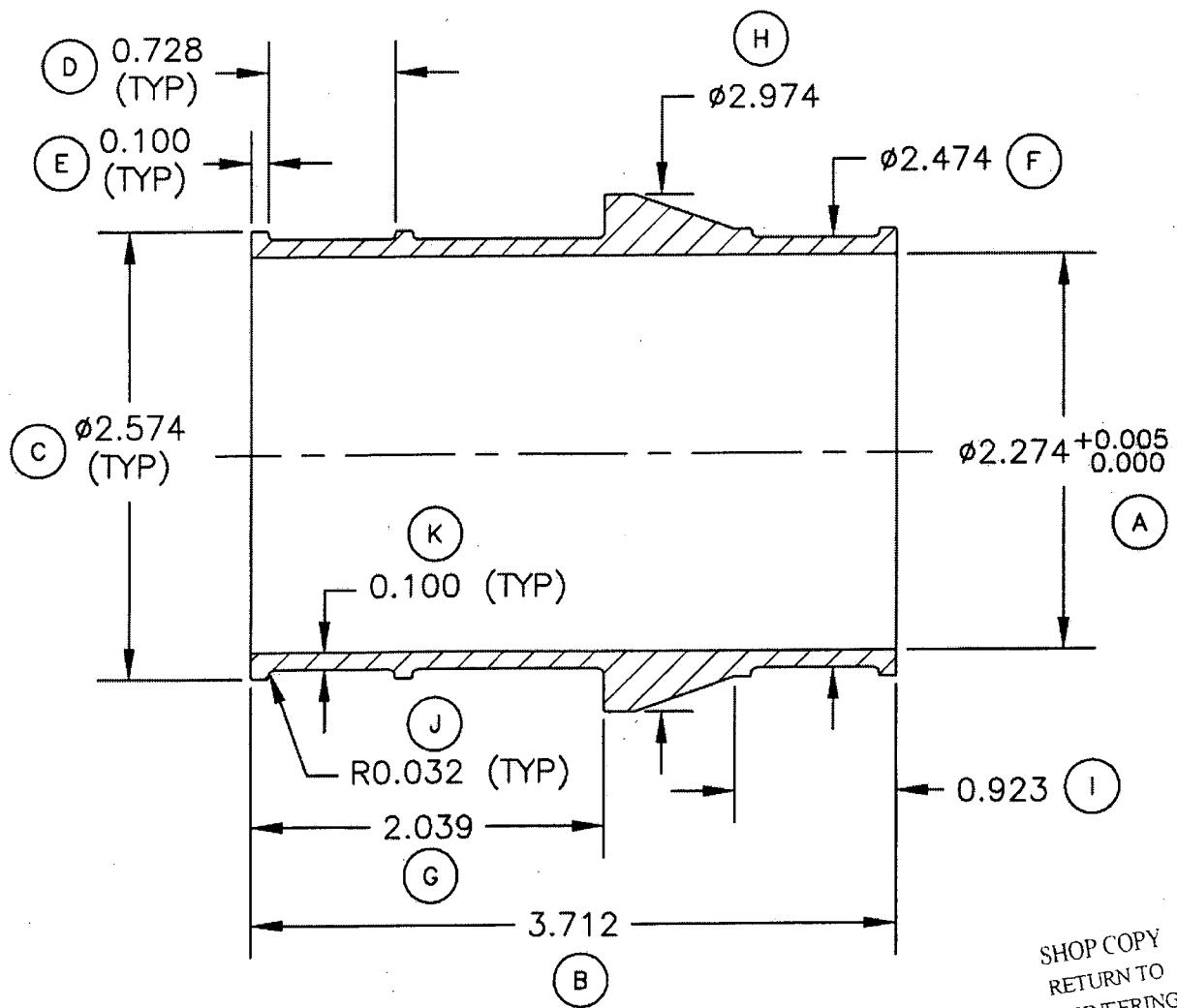
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A1	CP	02/01/23	UPDATE DIMS AS MANUFACTURED.
A		00.11.17	NEW ISSUE
DESIGN	DRAWN BY	CP	DART
CHECKED	APPROVED	CP	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
DATE		00.11.17	REV. A SHEET 1 OF 1 SCALE 1:1
TITLE		Ø2.250 SUPPORT	

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 *CH*D2891-1 TURNING DETAIL

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NO. *28388*

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VENUS WIRE INDUSTRIES LIMITED

REGD.OFFICE : 19 Raghuvanish Mill Compound, S. B. Marg, Lower Parel, Mumbai- 400 013. (INDIA)
Tel.: 91-22-24978840 Fax : 91-24978846 E-mail : Sales@Venuswires.com Website : WWW.Venuswires.com

ISO: 9001:2000
REGISTERED FIRM

INSPECTION /MILL/QUALITY CERTIFICATE

No. BB/VW/2006-2007/0765

PRODUCT INFORMATION	CUSTOMER	M/S. AMS SPECIALTY INC.								GRADE	AISI-630		
	INVOICE NO.	PM/042/EXP/2006-2007								HEAT NO.	VBMU-0622		
	PRODUCT FORM : STAINLESS STEEL BRIGHT BARS												
	DIMENSION	3 1/4"S.A.				Tol :- +/- 0.003"				QUANTITY	2050.30 LBS		
	IDENTIFICATION	AJ 2546											
CONDITION	ANNEALED, PEELED CENT.GROUND & POLISHED												
CHEMICAL COMPOSITION	ELEMENTS	C%	Si%	Mn%	P%	S%	Cr%	Ni%	Cu%	Mo%	N%	Nb%	NB+TA
	SPECIFIED	MIN	-----	-----	-----	-----	15.00	3.00	3.00	-----	-----	-----	0.15
	SPECIFIED	MAX	0.07	1.00	1.00	0.040	0.030	17.50	5.00	5.00	-----	-----	0.45
RESULTS		0.032	0.370	0.680	0.033	0.022	15.500	4.300	3.200	0.050	0.024	0.290	0.2904
MECHANICAL PROPERTIES		UTS		YS		R.A.%	ELONGATION %		HARDNESS				
	RESULTS	138.19 KSI		122.87 KSI		31.75	11.17		306 BHN				
HEAT TREATMENT : 1900°F SOLUTION ANNEALED RAPID COOLED.													
REMARKS : *CONTACT PROBE THERMOCOUPLES USED TO DETERMINE CHARGE TEMPRATURE. *MATERIAL IS FREE FROM MERCURY AND RADIUM CONTAMINATION. *NO WELDING PERFORMED. *DISC MACROETCHED AND NO PIPE OR CRACK OBSERVED. *MATERIAL PRODUCED WITHOUT OZONE DEPLETING SUBSTANCES. *MICROSTRUCTURE : 2.08% FERRITE. *MELTING PRACTICE EAF CONVERTOR TO VOD. *MATERIAL CONFORMS TO ASTM A564/A564-02A TYPE 630. CONDITION A. ASTM A370-03A, ASTM E340, ASME SA564/SA564M, AMS 5643Q, *THIS CERTIFICATE IS ACCORDING TO EN 10204/3.1B *AMS ORDER NO : 4277 *COPPER & BRASS ORDER NO. : CJ5743 *COUNTRY OF ORIGIN : INDIA													
<p>We hereby certify that the material described herein has been manufactured and tested with satisfactory results in accordance with the customers requirements, needs and expectations. Mechanical test results is the one result taken randomly from the lot.</p> <p style="text-align: right;">20</p>  <p>MANAGER Q.A.)</p>													
DATE : 18/07/2006													

PLANT : ATKARGAON, TAKAI ADOSHI ROAD, KHALAPUR, KHOPOLI- 410203.

DOC.No. F/QAD/06,R1

PHONES : 02192-262334/263404/262610 FAX :(02192) 2668873

For any information / query please quote Invoice No. & TC No. / Invoice No. & Bundle No.



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	DSK076	Support as per Dwg DSK076 D6104-003 B28388	2068
8	DSK076	Support as per Dwg DSK076 D6104-003 B28077	2068
10	DSK076	Support as per Dwg DSK076 D6104-003 B26715	2068
20	DSK077	Support as per Dwg DSK077 D6104-003 B28389	2068
8	DSK077	Support as per Dwg DSK077 D6104-003 B27970	2068
7	DSK077	Support as per Dwg DSK077 D6104-003 B28078	2068
14	DSK080	Support as per Dwg DSK080 D6104-011 B27266	2068

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, September 20, 2006